Work Order ID 85188 *85188* Page 1 June-04-12 1:29:41 PM Item ID: D350-636-101 Accept *N900040100* Setup Start **Revision ID:** Item Name: Toe Step, LH/RH 04/06/2012 Start Qty: 6.00 **Start Date: Cust Item ID: Customer:** Reference: Start Run Process Plan: MUJ Date: 1206 04 Tooling: Approvals: Date: Stop Date:____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp **Draw Nbr Revision Nbr** D3487 Rev A 100 0.00 DOCUMENT CONTROL MLJ 12107/19 *100* DC 0.00 Memo Document Control Photocopy bluefile & type labels per PPPD350-636-101 CHG001 -6061.100 110 0.00

110

Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg *** D3487-1***

Dwg Rev: Prog Rev:

2-Deburr if necessary

Jm 12-6-19

Dart Aerospac	e Ltd
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W/O:			W	ORK ORDER CHANG	BES		···		
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:							
	R	esolution:						Date: _	
NCR:			WORK ORE	DER NON-CONFORM	ANCE (NCI	₹)			
DATE	STEP	Description of NC			tion B		cation	Approval	Approval
DAIL	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector
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Work Orde June-04-12 1:2		188		*8518	38*		1 1 Tarita	, ,		Page 2
Item ID: Revision ID: Item Name:	D350-636-10			Accept	*N9000	4010) ()*	Setup Star	ı VI.	S1* S2*
Start Date: Required Date: Reference:	04/06/2012 18/06/2012	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item ID: Customer:				IV.	
Approvals:	Process Pla	ın:	Date:	_ 0	Date:		_	Run Star Stop	, "I V I	R1* R2*
Sequence ID/ Work Center II	D	Operation Description QC2- Inspect parts off m	achine FAI/FAIB	Set Up/ Run Hours 0.00	Tool ID T	Cod # Plai		Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control		Memo		0.00			6_			Jm 12-6-
130 *130* QC Quality Control		QC8- Inspect parts - seco	and check	00.00 Toxel	૧		(46)	<u> </u>		
150 *150* Brake NC		NC BRAKE Memo		0.00			_6_			Sp 12/67/1

Brake NC

Form as per Dwg D3487

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANG	ES				•
DATE	TE STEP PR t No:PAR #: Resolution: TE STEP Description of NC Section A	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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		•							
Part No	:	PAR #:	_ Fault Ca	tegory:	_ NCR: Yes	No DQ	A :	_ Date: _	
	R	esolution:	_ Disposit	ion:	_ QA: N/C Cld	osed:		Date: _	
NCR:		W	ORK OR	DER NON-CONFORMA	ANCE (NCR)			
DATE	STED	Description of NC		Corrective Action Secti		Verific	cation	Approval	Approval
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sect	ion C	Chief Eng	QC Inspector
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Work Orde		188	·	*851	188*							Page 3
Item ID: Revision ID: Item Name:	D350-636-10			Accept	*N900	040	100	N *	Setup St	art *	NS NS	31* 32*
Start Date: Required Date: Reference:	04/06/2012 18/06/2012	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item Customer:	D:					IVI	17
Approvals:		n:	Date:			ate:]		art *	NF NF	२1* २2*
Sequence ID/ Work Center II 160 *160* QC Quality Control)	Operation Description QC5- Inspect part complet Memo	teness to step on W/O	Set Up/ Run Hours 0.00 0.00 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reje Num		Insp. Stamp
170 *170* HandFinish Hand Finishing		Chemical Conversion Coal	t per QSI005 4.1	0.00				6		N.	12-	7-19
*180 *180* Powdercoat Powder Coating		White Gloss(Ref:4.3.5.1) p Memo ATTN: PAINT START TIME		0.00 0.00 NEW LAW PERATURE	:	7)		6X	<i>J</i>			M 12/0
1218	41		STa. Ten	TTimen of the second se	320 1e/10	50 0 F						÷

Dart	Aeros	pace	Ltd
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DATE STEP PROCEDURE CHANGE By Date						
	e Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No: PAR #: Fault Category: NCR: Yes No	DQA:	Date: _				
Resolution: Disposition: QA: N/C Closed:	QA: N/C Closed:					
NCR: WORK ORDER NON-CONFORMANCE (NCR)			-			
DATE STEP Description of NC Corrective Action Section B Ve	erification	Approval	Approval			
Section A Initial Action Description Sign & Date	Section C	Chief Eng	QC Inspector			

Work Order ID 85188 June-04-12 1:29:41 PM				Page 4				
Item ID: Revision ID: Item Name:	D350-636-101 Toe Step, LH/RH			Accept	*N900040	100*	Setup Start Stop	*NS1* *NS2*
Start Date: Required Date: Reference:	04/06/2012 18/06/2012	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item ID: Customer:			
Approvals:	Process Pla	an:			Date:	·	Run Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II 190 *100* HandFinish Hand Finishing)	Operation Description Wing Walk as per dwg Q Memo	0S1005 4.4 Batch 1 ^{\1} 1 \ 2	Set Up/ Run Hours		Plan Accep Code Qty		Reject Insp. Number Stamp
200 *200* QC Quality Control		QC3- Inspect Part Finish Memo		0.00		6	<u></u> ф	Bl 12719
210 *210* Packaging		Packaging Memo		0.00		6		12/07/208

Memo

Packaging

Identify and pack for shipping as per PPP D350-636-101 Location: 57 472
PPP Rev: _____

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANG	iES			•	
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Dat	e Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cat	tegory:	_ NCR: Ye	es No	DQA:	Date: _	
	R	esolution:	Disposit	ion:	_ QA: N/C	Closed:	;	Date: _	
NCR:		1	WORK OR	DER NON-CONFORM	ANCE (N	CR)			
DATE	STEP	Description of NC			tion B		erification	Approval	Approval
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng			Section C	Chief Eng	QC Inspector
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	Work Order ID 85188 June-04-12 1:29:41 PM			*85188*								Page 5
Item ID: Revision ID: Item Name:	D350-636-10		<u></u>	Accept	*N900040100			* Setup		Start Stop		S1* S2*
Start Date: Required Date Reference:	04/06/2012	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:					ŢŊ	5/"
Approvals:	Process Pla	ın:	Date:	Tooling:	Da	nte:		R	tun	Start	*N	R1*
	QC:		Date:	SPC (Y/N):	Da	ite:				Stop	*N	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #		Accept Qty	Rejo Qty		Reject Number	Insp. Stamp
*230 *230* QC		QC21- Final Inspection Memo	- Work Order Release	0.00			_			12	17/	234

Quality Control

Dart Aerospace Ltd

W/O:			WC	ORK ORDER CHANG	ES	4			•
DATE STEP	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	9 								
	}								
Part No	•	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Dispositio	n:	_ QA: N/C C	losed:		Date: _	
NCR:		V	VORK ORD	ER NON-CONFORMA	ANCE (NC	R)			
		Description of NC			ion B	Verific	cation	Approval	Approval
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC Inspector
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Picklist Print

June-04-12 1:29:45 PM

Work Order ID: 85188

85188

Parent Item:

D350-636-101

D350-636-101

Parent Item Name: Toe Step, LH/RH

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A New Issue 06-03-03 JLM

11.03.15 now made in house DD verf:JLM

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.100		Purchased	No			110	sf	69.7000	0.7942	(5.016)			
M6061T6	\$ 100								**	3.010			7 . _

M6061T6S 100

<u>Location</u>	Loc Qty	Loc Code	
MAT021	69.7		_
102201	1		
118072	5.7		
118523	63		11852

Jm 12-6-19

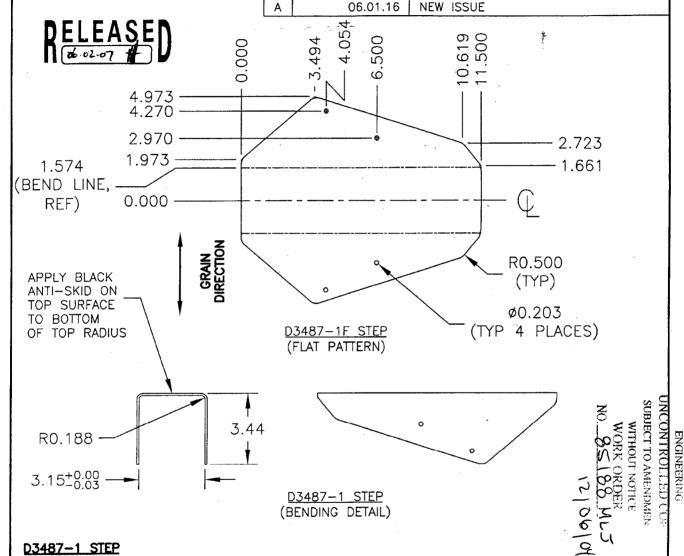
Page 1

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W/O:		WORK ORDER CHANGES					-			
DATE	STEP	PROC	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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							*	+		
Part No	:	PAR #:	_ Fault Ca	tegory:	NCR: Yes	No DO	QA:	Date: _		
	R	esolution:	esolution: Disposition: QA				QA: N/C Closed: Date:			
NCR:		W	ORK OR	DER NON-CONFORMA	NCE (NC	R)				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	on B Sign Dat	& Sec	fication ction C	Approval Chief Eng	Approval QC Inspector	
-										
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DESIGN PH	DRAWN BY	DART	AEROSPACE PORT HADLOCK, V	
CHECKED M	APPROVED #	DRAWING NO.		REV. A
H	#	D3487		SHEET 1 OF
DATE		TITLE		SCALE
06.01.16		STEP		1:4
		1		



D3487-1 STEP

MATERIAL:

ALUMINUM 6061-T6/T651 ALUMINUM (QQ-A-250/11) 0.100 THICK

(REF DART MATERIAL SPEC M6061T6S.100)

FINISH: 2)

CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3

APPLY BLACK ANTI-SKID PAINT TO TOP SURFACE PER DART QSI 005 4.4

- ALL DIMENSIONS ARE IN INCHES 3)
- ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4)
- PART IS SYMMETRICAL ABOUT CENTERLINE 5)
- BREAK UNMARKED EDGES 0.005 TO 0.010 MAX

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W/O:		700	WO	RK ORDER CHANGE	S				
DATE STÉP		PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
								,	,
Part No);	PAR #:	Fault Cate	gory:	NCR: Yes	No I	DQA:	Date: _	
	Res	solution:	Disposition	n:	QA: N/C	closed:		Date: _	
NCR:			WORK ORDE	ER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC	NC Corrective Action				rification	Approval	Approva
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& 2	Section C	Chief Eng	QC Inspect
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DART AEROSPACE LTD	Work Order:	85/88
Description: Step	Part Number:	D3487-1
Inspection Dwg: D3487 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.203	+0.005/-0.001	0.204"	~		1/	mmol
3.494	+/-0.010	3.495"	-		7	N N
4.054	+/-0.010	4,660"	V	1	V	N
6.500	+/-0.010	6.495"	<u>ب</u>		1/	ů.
10.619	+/-0.010	10.619"	~		. V .	Bodinjas
11.500	+/-0.010	11.500"			V	Pradutos
1.973	+/-0.010	1,973"	~		ν	Mmai
2.970	+/-0.010	2, 973	~		V	17
4.270	+/-0.010	4.273)		V	Productor
4.973	+/-0.010	4.9.73"	~		V	71
0.100	+/-0.010	0.097	_		Ŭ	MMGT
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Measured by:	JM	Audited by:	Preliminary Approval:	
Date:	12-6-19.	Date: 7/06/6	Date:	
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Rev	Date	Change	Revised by	Approved
Α	11.03.24	New Issue	KJ 💖	224
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